

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017739**Date Inspected:** 31-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le Feng, Zhao Chen Sun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG/TOWER**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

TOWER DOCK, TOWER LIFT 4 CROSS BRACE GUSSET PLATE (NWIT # 07176)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and random Visual Testing (VT) of an area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

WD1-GUSA3-3-119M-N-003A/B, 004A/B

This Quality Assurance (QA) Inspector observed the following work in progress:

TOWER DOCK

TOWER LIFT 4, CROSS BRACE GUSSET PLATE REPAIR (T-WR3737)

SMAW welding of weld joint 003A/B located on WD1-GUSA3-3-119M-E.

Welder is identified as 202323. ZPMC CWI is identified as Mr. Zhao Chen Sun.

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The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G(4F)-FCM-REPAIR.

During random in process inspection this QA inspector observed that AB/F NDT personnel were performing Ultrasonic Testing (UT) on the weld joint of cross brace gusset plate of tower lift 4. During inspection AB/F NDT personnel found class "A" rejectable indication and the indication with details clearly marked on the components. The members are identified as Tower Components. The weld designations reviewed are as follows.

WD1-GUSA3-3-119M-S-003A/B

During random in process inspection this QA inspector observed that ZPMC personnel were performing excavation on the weld joint of cross brace gusset plate of tower lift 4, which was ultrasonically rejected by AB/F NDT personnel. The members are identified as Tower Components. The weld designations reviewed are as follows.

WD1-GUSA3-3-119M-S-003A/B

BAY 10

OBG BIKE PATH

FCAW welding of weld joint 070 located on BK004A6-028.

Welder is identified as 053869. ZPMC QC is identified as Mr. Yu Zhi Lai.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-P4-F.

FCAW welding of weld joint 078 located on BK004A8-028.

Welder is identified as 057180. ZPMC QC is identified as Mr. Yu Zhi Lai.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-P4-F.

TOWER GRILLAGE COVER PLATE

SAW welding of weld joint 048B located on SSD1-TL5-1B-F.

Welder is identified as 040460. ZPMC QC is identified as Mr. Li Peng Fei.

The welding variables recorded by QC appeared to comply with WPS-B-T-3221-B-U3c-S-1.

BAY 11

OBG BIKE PATH

FCAW welding of weld joint 002 located on BK004A2-053.

Welder is identified as 205649. ZPMC QC is identified as Mr. Xu Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

FCAW welding of weld joint 045 located on BK004C1-024.

Welder is identified as 040759. ZPMC QC is identified as Mr. Mao Bin Bin.

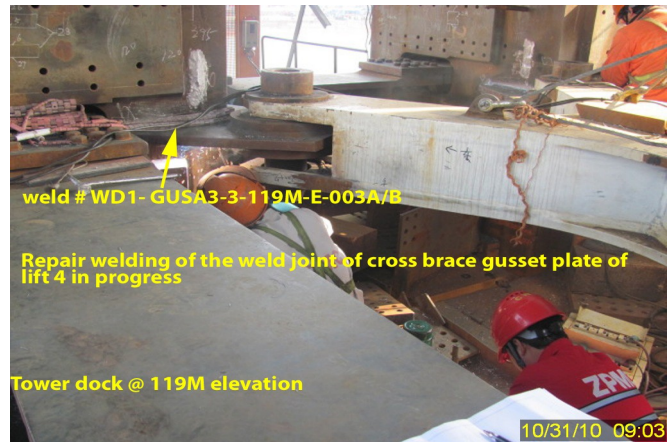
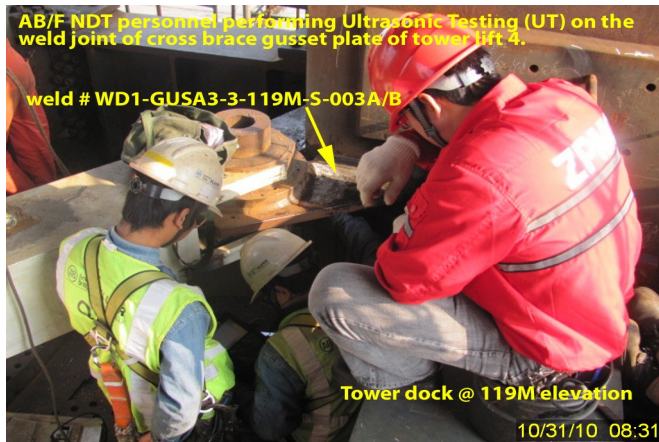
The welding variables recorded by QC appeared to comply with WPS-B-T-2231-B-U2-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract

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documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Gaikwad,Umesh

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer